Work Order ID 77357 December-06-11 10:28:36.AM				*77357*								Page 1				
Item ID: Revision ID: Item Name:	D350-591-3 Heli-Access-S	12 Step, Long RH			Accept	*N900	040	100)*	Setup	Start Stop	*N *N	S1* S2*			
Start Date: Required Date: Reference:	06/12/2011 : 30/01/2012	Start Qty: 5.00 Req'd Qty: 5.00		*5* *5*		Cust Item I Customer:	D:									
Approvals:		nn: M.L.J		115/06			ate:			Run	Start Stop	*N *N	R1* R2*			
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	•	Reject Number	Insp. Stamp			
Draw Nbr	Rev	ision Nbr														
D3272	Rev	В								_						
1 nn DC Document Control		DOCUMENT CONTE Memo Photocopy	1	pe labels as pe	0.00 0.00 or PPP D350-591-312	CHG001 & 12 (ાીાજ			Jos	ML	5 17	2-1-11			
110 *110* Large Fab Large Fab		Large Fab Memo 1-Bevel e	nd for welding F	WD ONLY	0.00	Mis	P·O/·	03	5		ø					
		D3272	upport using Jig luminum Rod		Fwd End Plate as per (QSI 004 & Dwg										

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N/O:		WORK ORDER CHANGES												
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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				,										
Part No	•	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA: _	Date: _							
	Re	esolution:	Disposit	ion:	_ QA: N/C CI	osed:	Date: _	·						
ICR:			WORK OR	DER NON-CONFORMA	NCE (NCR	3)								
DATE	STEP	Description of NC		Corrective Action Section	on B Sign &	Verification		Approval						
	012.	Section A	Initial Chief Eng	Action Description Chief Eng	Date	Section C	Chief Eng	QC Inspector						
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Work Order ID 77357 December-06-11 10:28:36 AM			*77357*						Page 2			
Item ID: Revision ID: Item Name:	D350-591-31 Heli-Access-Si			Accept	*N900	040	10	n *	Setup	Start Stop	· i VI •	S1* S2*
	06/12/2011	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item l Customer:	ID:					IV.	.72
Approvals:	Process Pla	n:	Date:	Tooling:	D:	ate:			Run	Start	*NI	₹1*
	QC:		Date:	_ SPC (Y/N):	D :	ate:				Stop	*NI	₹2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hour	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
120 *170* QC Quality Control		QC9- Inspect visual per (QSI004- Fusion Welds	0.00				5		Ø	BE.	12-01-6
130 *130* QC		QC5- Inspect part comple	eteness to step on W/O	0.00	idoloy			_K_				
Quality Control		Memo		0.00	(RH				
140 + 4 4 0 +		Chemical Conversion Co	at per QSI005 4.1	0.00	ísa .							
140 HandFinish		Memo		0.00	AL 12-01-0.	5		Ś			<u>_</u>	

Hand Finishing

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W/O:			V	VORK ORDER CHA	NGES					*
DATE	STEP	PRO	OCEDURE CH	IANGE	1	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	<u> </u>	PAR #:	Fault Ca	teaorv:	NCR:	Yes N	lo DQ /	<u> </u> A:	Date:	
		esolution:								
NCR:				DER NON-CONFOR						
DATE	STEP	Description of NC		Corrective Action	Section B	01		ation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Descript	ion	Sign & Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID 77357 December-06-11 10:28:36 AM				*77357*								Page 3		
Item ID: Revision ID:	D350-591-31				Accept	*N900	040	100	ገ*	Setup	Start Stop	*N	S1*	
Item Name:	Heli-Access-S	-									эгор	*N	S2*	
Start Date: Required Date: Reference:	06/12/2011 30/01/2012	Start Qty: 5. Req'd Qty: 5.		*5* *5*		Cust Item l Customer:	i D :							
Approvals:	Process Pla	n:	Date:		Tooling:	D:	ate:		1	Run	Start	*N	R1*	•
	QC:		Date:		_ SPC (Y/N):	Da	ate:				Stop	*N	R2*	•
Sequence ID/ Work Center II)	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	
150		QC3- Inspect Part	Finish		0.00								, 1	
150 QC Quality Control		Memo)		0.00		(8010)	ich di	5 RH MCA SUI	1	/	II 17	1610	6
180					0.00									
180 Large Fab		Large Fab Memo	1		0.00				×5	4	<u></u>			_
Large Fab		1-Asse	emble Leg Asseml	oly as per Dwg	g D3272.									
		2-Leav	e one rivet out un	til welding is										
		3-Beve	el Aft end for weld	ling	> A	e 12/01	101							
		4-Insp	ect for foreign obj	ect as per QSI	024		06							
		5-Weld A/RAI	d Aft End Plate as uminum Rod_//	per QSI 004 8	& Dwg D3272	e 12/01. U 12.01.	06							
		6-Grin	d End Plate flush			v -								
		7-Insta	Il last rivet as per	Dwg.										

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DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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Part No		PAR #:													
		esolution:	Disposition	I	_ QA: N/C (Closed:	· · · · · · · · · · · · · · · · · · ·	Date: _							
NCR:				R NON-CONFORM		R)									
DATE	STEP	Description of NC			ion B Sign		cation	Approval	Approval						
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Dat		ion C	Chief Eng	QC Inspector						
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Work Orde				*773	357*							Page 4
Revision ID:	D350-591-31			Accept	*N900	040	100)* ፡	Setup	Start Stop	*N:	S1*
	Heli-Access-S 06/12/2011 30/01/2012	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:				•	"IN	S2*
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:		Ī	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 190 *100* QC Quality Control	•	Operation Description QC10- Inspect visual per	QSI004- ground welds	Set Up/ Run Hours 0.00 0.00 17 lo	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
200 *200* QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00	2/01/13	·		- 25 Pr				
210 *21 0* HandFinish		Chemical Conversion Co	at per QSI005 4.1	0.00				_5	£	L.	12/0/	6

Hand Finishing

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W/O:			WORK ORDER CHANGES													
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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Part No:	·	PAR #:	Fault Cate	gory:	_ NC	R: Yes	No DQ	A:	Date:							
		solution:	Disposition	ı:	QA	: N/C CI	osed:		Date: _							
NCR:		\	WORK ORDER NON-CONFORMANCE (NCR)													
DATE	STEP	Description of NC	Corrective Action Section			0:		ation		Approval						
DAIL		Section A	Initial Chief Eng	Action Description Chief Eng		Sign 8 Date	Secti	on C	Chief Eng	QC Inspector						
	<i>'</i>															
		•														
		317-20-00-00-00-00-00-00-00-00-00-00-00-00-						· · · · · · · · · · · · · · · · · · ·								
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Work Order ID 77357 December-06-11 10:28:36 AM				*77		Page 5				
Item ID: Revision ID:	D350-591-3	12		Accept	*N900	<u>04010</u>	N *	Setup	Start	*NS1*
Item Name:	Heli-Access-S	Step, Long RH							Stop	*NS2*
Start Date: Required Date Reference:	06/12/2011 : 30/01/2012	Start Qty: 5.00 Req'd Qty: 5.00		5* 5*	Cust Item II Customer:	D :				
Approvals:	Process Pla	an:	Date:	Tooling:	Dat	te:	_	Run	Start	*NR1*
	QC:		_ Date:	SPC (Y/N):	Dat	te:	_		Stop	*NR2*
Sequence ID/ Work Center I 220 * 220 * 220 * Powdercoat Powder Coating 230 * 230 * 230* HandFinish	2	OVEN TEM	ie: 2 - 1	15 0.00 320 ⁵ 5	Tool ID	Tool# Plan Code	e Qty 5X/		M-D	Reject Insp. Number Stamp 12/61/1
240 *240* QC Quality Control		QC3- Inspect Part Finish Memo		0.00		(ounte		F		12/6//12

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W/O:			WO	ORK ORDER CHANG	ES				1
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									411-178-178-178-178-178-178-178-178-178-1
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	s No DO)A:	Date: _	
	Resolution:		Dispositio	n:	_ QA: N/C	Closed: _		Date:	·
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			ion B	Verif	ication	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da		tion C	Chief Eng	QC Inspector
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Work Ord December-06-1				*773	357*							Page 6
Item ID: Revision ID:	D350-591-3			Accept	*N900	040°	100	* :	Setup	Start Stop	*N:	S1*
Item Name: Start Date: Required Date Reference:	Heli-Access-S 06/12/2011 : 30/01/2012	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:					"INI	S2*
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:		I	Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center I 250 *250* Packaging Packaging	D	Operation Description Pick Kit Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Jumber	Insp. Stamp
260 *260* QC Quality Control		QC4- 100% Inspect kits f Memo	for completeness	0.00	ul8			+5 P+1				
270 *270* Packaging Packaging		Packaging Memo Identify and p Location:	pack for shipping as per I	0.00 0.00 PPPD350-591-312			-		6	[] [4]	[][]	r (F)

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	DCEDURE CHA	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	_ NCR: Ye	s No DO	QA:	Date: _	
	Res	solution:	Disposition	on:	_ QA: N/C	Closed: _		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NO	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigi Da		ction C	Chief Eng	QC Inspector
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	Vork Order ID 77357 December-06-11 10:28:36 AM			*77357*							Page 7		
Item ID: Revision ID: Item Name:	D350-591-3 Heli-Access-S	12 Step, Long RH		Accept	*N900	040	100)*	Setup	Start Stop	1/1	S1* S2*	
Start Date: Required Date: Reference:	06/12/2011 30/01/2012	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item I Customer:	D:							
Approvals:	Process Pla	ın:	Date:	Tooling: SPC (Y/N):	· · ·	ate:			Run	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 280 *2RA* QC Quality Control)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	

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W/O:			WC	RK ORDER CHANG	GES					, ,			
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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			·										
Part No		PAR #:	Fault Cate	gory:	NCF	R: Yes N	lo DQ	4 :	Date:	· 			
	Res	solution:	Disposition);	QA:	N/C Clo	sed:		Date:				
NCR:			WORK ORDI	ER NON-CONFORM	IANCE	(NCR)							
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B	Sign & Date			Approval Chief Eng	Approval QC Inspector			
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Picklist Print

December-06-11 10:28:40 AM

Work Order ID: 77357

77357

D350-591-312 Parent Item:

D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 06/12/2011

Required Date: 30/01/2012

Page 1

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

fixe route sea in bom DD 10.04.28 verified by:EC

IPP Rev:D

	ke route seq in boi	m DD 10.04.28	vermed	by:EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	20.0000	1	5			
D3272-1	·								**	L	11.10	2.28	
				<u>Location</u> WA	B773	60E5	Oty 20	Loc Code		5			
	ji.			***	76038 76039		10 10		· · · · · · · · · · · · · · · · · · ·		_		
D3067-1 .		Manufactured	No			110	Each	125.0000	1	5	11		
D3067-1		•							**	1	212.0	y. O.	2
				Location	:	Loc (<u>Oty</u>	Loc Code					;
				WA016			125				_		
					67582	-	2				_ '		
					68214		1		_		_		
••					75468 76179		32 90			5	_		
D3219-1		Manufactured	No		70177	110	Each	106.0000	2	10	-		
D3219-1									**		1212.0	01.00	2
				Location		Loc C	<u>Qty</u>	Loc Code					
				WA016	77674		106			10	_		
				ę	73410		34				_		
					76226		72						

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W/O:			WO	RK ORDER CHANG	iES .				,
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Ye	s No DC	A:	Date: _	
	Resolution:		Disposition	:	_ QA: N/C	Closed: _		Date: _	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (N	CR)			
DATE	STEP	Description of NC			tion B		cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Da		tion C	Chief Eng	QC Inspector
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Picklist Print December-06-11 10:28:40 AM							i in	Page 2
Work Order ID: 77357		*7	7357*					
Parent Item: D350-591-312 Parent Item Name: Heli-Access-St	ep, Long RH		350-591-3	312*	Start Date: 06/12		uired Date: 30	
					Start Qty: 5.00		uired Qty: 5.0	00
*D3066-1 *D3066-1* Spacer	Manufactured	No		180 Each	148.0000 2 **	10 Ae	12/01	100
MS20600-AD4W4	Purchased	No	Location WA015 75076 76180	Loc Oty 148 48 100 180 Each	Loc Code 2,362.000 16	X10		
*M\$20600-AD4			Location ST321 <u>B/1988</u>	23 Loc Oty 2357 59	·		Ae	12.01.06
			117364 117601 117885 118840 119860 WA018	253 200 195 1150 500			·	
D3065-041 *D3065-041* Step Leg Assembly Hi	Manufactured	No	110/12	5 180 Each	**X5)_B	5 377054	Ae	12.01.0
			Location WA 37705 66149	$ \underbrace{\frac{\text{Loc Oty}}{33}}_{0} $	Loc Code	5		

31

76193

76194

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W/O:			W	ORK ORDER CHANG	ES		,					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No	•	PAR #:	Fault Cat	egory:	_ NCR: Yes	No DQ	A:	_ Date: _				
	Re	esolution:	Dispositi	on:	_ QA: N/C CI	osed:						
NCR:		1	WORK ORE	DER NON-CONFORMA	NCE (NCF	l)						
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector			
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Work Order ID: 77357

December-06-11 10:28:40 AM

77357

Parent Item Name: Heli-Access-Step, Long RH

Parent Item:

D350-591-312

D350-591-312

Location

ST353

Start Date: 06/12/2011

Required Date: 30/01/2012

Page 3

Start Qty: 5.00

Required Qty: 5.00

D3067-1

D3067-1

End Plate

Manufactured

180

Each 125.0000

AN3-35A

No

Loc Oty Location WA016 125 67582 68214 1 32 75468 76179 90 250 Each

145.0000

Loc Code

Manufactured No

Purchased

Loc Qty 145 117619 3 119449 100 119641 42 250 Each

147.0000

Loc Code

Loc Code

**

Support Assembly

Manufactured No

Loc Oty Location ST481 147 47 73411 100 75547 250

Each

62.0000 **

Location ST481 76169 76170 Loc Qty 62 35 27

Loc Code

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W/O:			W	ORK ORDER CHANGE	S				•
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	on:	QA: N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Corrective Action Section B			Verifica		Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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December-06-11 10:28:40 AM

Work Order ID: 77357		*77357*			
Parent Item: D350-591-312 Parent Item Name: Heli-Access-Step, L	ong RH	*D350-591	I-312*	Start Date: Start Qty:	
AN960JD416 NAS1149D0463J *AN960.ID416* Washer	Purchased	No	250 Each	0.0000 16	~~
AN960JD516 - NAS1149D0563J ** AN960.ID516*	Purchased	No	250 Each	0.0000 4 **	M119075 20 M118208 D
AN5-36A Bolt	Purchased	No	250 Each	144.0000 2 **	^
D2618 *D2618*	Manufactured	Location ST340 118451 119449 119641 No	Loc Oty 144 19 50 75 250 Each	Loc Code 152.0000 2 **	10
D2230-3 *D2230-3*	Manufactured	Location ST019 74458 76130 No	Loc Oty 152 52 100 250 Each	99.0000 . 4°	1 10 10 10 10 10 10 10 10 10 1
Lug		Location ST480 53881 70973 74440 75546	Loc Oty 99 4 1 10 84	Loc Code	

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W/O:			M	ORK ORDER CHANC	GES				
DATE	STEP	PRO	OCEDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	ļ								
Part No		PAR #:	Fault Ca	tegory:	NCR: Yes	No DC	A:	Date: _	
	Resolution: Disposition: QA: N/C (Closed:		Date: _		
NCR:			WORK OR	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial		tion B		cation	Approval	Approval
	0.2.	Section A	Chief Eng	Action Description Chief Eng	Dat	I JEC	tion C	Chief Eng	QC Inspector
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Picklist Print Page 5 December-06-11 10:28:41 AM Work Order ID: 77357 *77357* D350-591-312 *D350-591-312* Parent Item: Parent Item Name: Heli-Access-Step, Long RH Start Date: 06/12/2011 **Required Date:** 30/01/2012 Start Qty: 5.00 Required Qty: 5.00 D2856-400 Manufactured 250 f 252.2445 1.2 *D2856-400* ** Abraison Strip Location Loc Qty Loc Code ST409 252,2445 63735 0.6696 68076 0.3149 71164 37.86 213.4 cut (2) D2856-400-720 as per dwg MS21042L3-No 250 7,467.000 Purchased Each ** Location Loc Qty Loc Code ST300 87 117441 16 117885 35 5 118451 118927 31 ST516 5994 119017 5994 ST518 1385 119075 1385 AN4-13A No 250 Each 980.0000 Purchased ** Location Loc Code Loc Qty ST357 980 118078 17 118838 363 119449 500 100

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W/O:			WO	RK ORDER CHANG	ES				•
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cated	iorv:	NCR: Yes	No DQ	A:	Date:	
		olution:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCF	1)			
DATE	STEP	Description of NC		·	ion B		cation	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	on C	Chief Eng	QC Inspector
		Design Control of the							

Picklist Print December-06-11 10:28:-	41 AM					Page 6
Work Order ID: 77357		*7	7357*			:
Parent Item: D350-59 Parent Item Name: Heli	91-312 -Access-Step, Long RH)350-591-3	312*	Start Date: 06/12/2011 Start Qty: 5.00	Required Date: 30/01/2012 Required Qty: 5.00
MS21042L5	Purchased	No		250 Each	2,192.000 2 10	
*M\$210421					**	V
			Location	Loc Qty	Loc Code	
			ST300	692		<u></u>
			116105	5		
			116548	43		
			117611 118179	52 496	10	
			118779	96		
			ST518	1500		
			119109	1500	,	/
MS21042L4 *MS21042I	Purchased 4*	No		250 Each	10,136.00 8- 40	
Nut			Location	Loc Qty	Loc Code	
			ST300	526		
			117441	51		
			117601	342		<u> </u>
			118451	133		
			ST516	4605	40	
		•	119017	4605	70	<u> </u>
			ST518 119075	5000 5000		
AN960JD10 N	VAS1149D0363J Purchased	No	117073	250 Each	0.0000 41 20	_
	0*				** M170	142 n/1/198/5

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Dart /	Aerospace l	Ltd
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W/O:			wo	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										
						·				
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Ye	es N	o DQ	A :	_ Date: _	
	Re	esolution:	Disposition	n:	QA: N/C	Clos	ed:		Date: _	·
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (N	CR)		·		
DATE	STEP	Description of NC	Corrective Action Section			0		cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Secti	ion C	Chief Eng	QC Inspector
							:			



			·	•
DESIG	P	DRAWN BY	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D .
CHECK	SED	APPROVED	DRAWING NO.	REV. B
	E	女	D3272 sh	EET 1 OF 3
DATE			TITLE	SCALE
07.0	5.18		STEP ASSEMBLY, HI LONG	NTS
Α		04.03.01	NEW ISSUE	
В		07.05.18	D3272-1 WAS D2622-120	

RELEASED

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET
	<u> </u>		

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO <u>77357</u> M.C. J

11/12/06

Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	GES		<u></u>			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector	
				, , , , , , , , , , , , , , , , , , , 				1 Tod Wigi		
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	Date: _) .			
	Re	esolution:	Dispositio	n:	QA: N/C (losed:		Date: _		
NCR:		,	WORK ORD	ER NON-CONFORM	ANCE (NC	R)				
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval	
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC inspector	
. 										

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



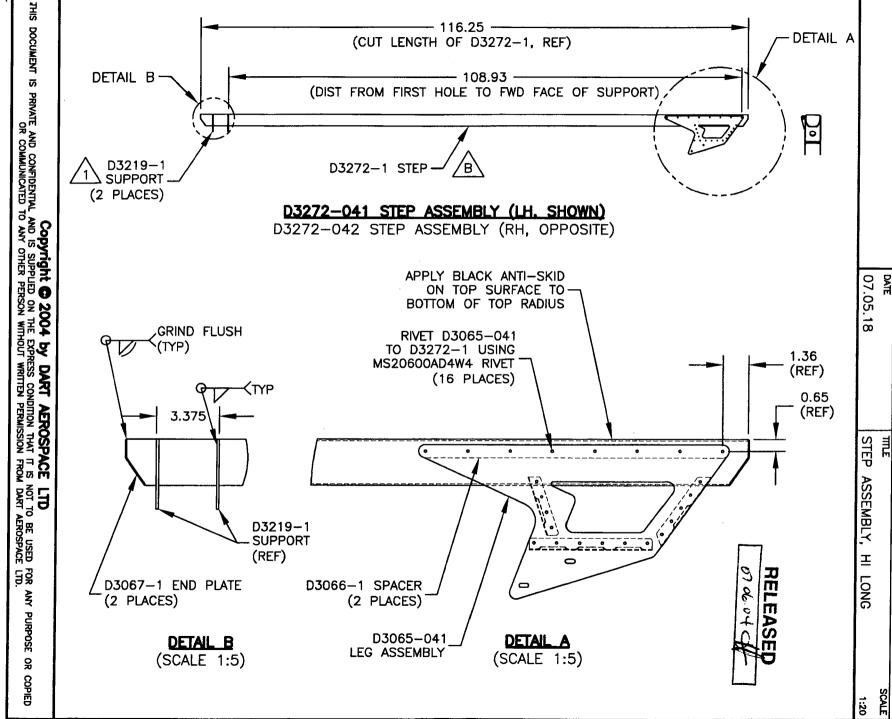
DRAWING NO. D3272

SHEET

2 OF 3

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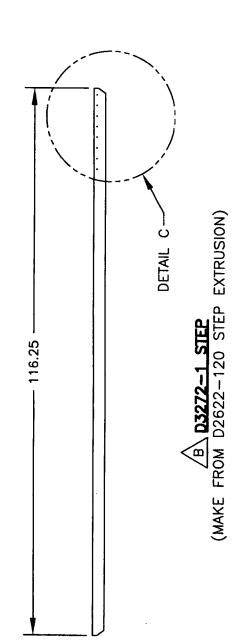


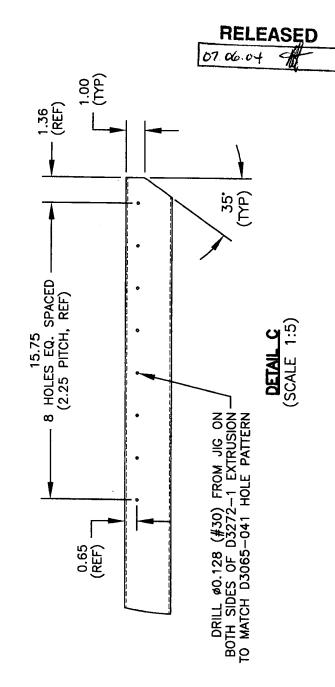
Dart Aerosp	ace Ltd
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D uit 710	oopaoo .										
W/O:			WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE By Date Qty Chief En							Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No: PAR #:		PAR #:	Fault Category: NO			NCR: Yes No DQA: Date:					
	Res	solution:	Disposition:			QA: N/C Closed: Date:			Date:	•	
NCR:			WORK ORDE	R NON-CONFO	RMANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &	Verific		Approval	Approval	
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector	
			3								
					· · · · · ·						



DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA CHECKED APPROVED DRAWING NO. REV. B D3272 SHEET 3 OF 3 DATE TITLE SCALE 07.05.18 STEP ASSEMBLY, HI LONG 1:20





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Dart Ae	rospace Li	d								
W/O:			WO	RK ORDER CHANG	ES					. 4
DATE	STEP	PR	OCEDURE CHAI	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,						
							· · · · · · · · · · · · · · · · · · ·			
Part No	:	PAR #:	Fault Categ	jory:	NCF	R: Yes	No DQ	A:	_ Date: _	
-	Resc	olution:	Disposition	:	QA:	N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCF	1)			
		Description of NC	Description of NC Corrective Action Section B Verification					Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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DART AEROSPACE LTD.



D350-591 Page 23 of 23

Qty	Ohi	Qty	Qty	Qty	Otr. I	Ohr	Ohi	Part Number	Description
-211	Qty -212	-213	-214	-215	Qty -216	Qty -311	Qty .	Part Number	Description
	-212	-213	-214	-210	-210	-311	-312 (D050 504 044	Mali Assass Otas TM Lang Chan Liliah Chia LLL
X	-,-						<u> </u>	D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	Х				-			D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		Х						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			Х					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
			· .	Х				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					Х			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						Х		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							Х	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
								500-0011	CTED ACCEMBLY (HOLL ONC THE
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1					ļ	D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2		,	D2230-1	MOUNTING LUG
		2	2	2	2	4	14	D2230-3	MOUNTING LUG
8	8						c.	D2274	RADIUS BLOCK
						2	12	D2618	BUSHING
4	4	4	4	4	4		A	D2732-030	*CUSHION
2	2	1	1	1	1	2	1 2	D2856-400-720	ABRASION STRIP
2	2			ì			1	D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	· 2	D3235-1	MOUNTING LUG
						1	1/1	D3278-041 -	SUPPORT ASSEMBLY
							<u> </u>	14 176	
2	2	2	2	2	2	2 4	2	AN3-35A	BOLT
10	10	2	2	2	2		- 1000 - 11 - 11 -	AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A -	BOLT
						2		AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	✓ 16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	1.2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
	İ					1	1 7	*DSI 9410-011	STEP MODIFICATION KIT

^{*}DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.